

Work Order ID 67022

Thursday, March 03, 2011 11:55:08 AM



Page 1

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/3/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: H Date: 11-03-3

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per File D3167-1_BLANK								②
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr								②
<i>Batch Prog</i>									
<i>Jan 11</i>									
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

B11-3-8

SL 11/03/14

SL 11/03/14

2

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67022

Thursday, March 03, 2011 11:55:09 AM



Page 2

Item ID: D3167-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 3/3/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M.A 11/03/14

2

0

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

PPP 65738

P 4/3/15 (2)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15

MF 11-03-15

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Picklist Print

Thursday, March 03, 2011 11:55:15 AM

Page 1

Work Order ID: 67022

Parent Item: D3167-1

Parent Item Name: Bearpaw



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

362.1000

3.6

7.2



UHMW 1" Black



18113-8

Location

Loc Qty

Loc Code

MAT

362.1

115955

38.8

116554

108.3

116796

12

116797

203

116797

2

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 67022
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.06 x 45°	/		vern JL-3	
B	5.80	+/-0.030	5.795	/		"	
C	0.25 x 45°	+/-0.030	0.25 x 45°	/		"	
D	R0.25	+/-0.030	.25	/		R-G	
E	0.200	+/-0.030	.202	/		"	
F	0.250	+/-0.010	.252	/		"	
G	0.625	+/-0.030	.625	/		"	
H	0.375	+/-0.010	.385	/		"	
I	0.950	+0.030/-0.010	.955	/		"	
J	3.21	+/-0.030	3.200	/		"	
K	19.00	+/-0.030	19.00	/		m=tape	
L	Ø0.260	+0.005/-0.000	.260	/		"	
M	Ø0.93	+/-0.030	.925	/		"	
N	0.30	+0.030/-0.000	.312	/		"	
O	0.375	+/-0.030	.379	/			
P	7.23	+/-0.030	7.225	/		vern CNC-02	
Q	4.54	+/-0.010	4.540	/		"	
R	2.00	+/-0.030	2.00	/		"	
S	12.000	+/-0.010	12.00	/		vern CNC-02	
T	6.000	+/-0.010	6.00	/		vern CNC-02	
U	23.75	+/-0.030	23.75	/		m=tape	

Measured by: SL
Date: 11/03/14

Audited by: B.A
Date: 11/03/14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	

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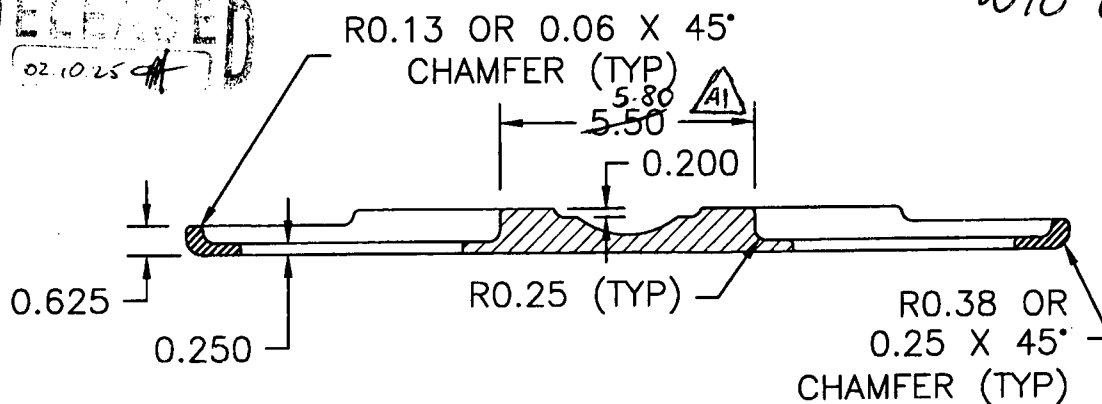
NOTE: Date & initial all entries



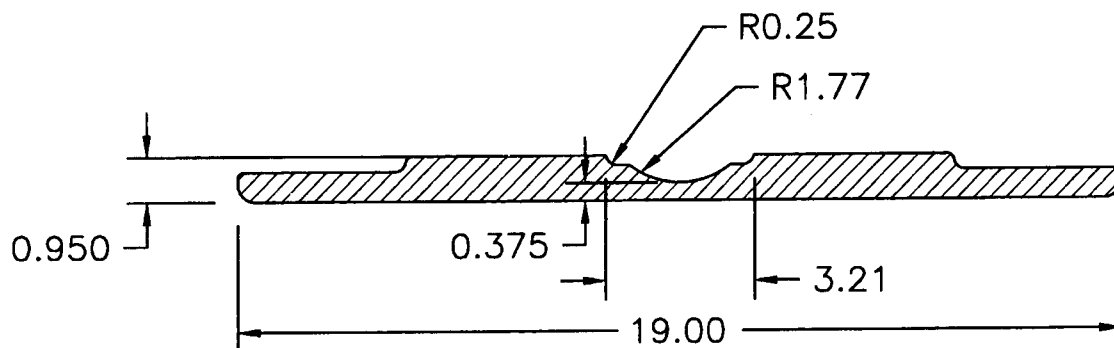
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

RELEASED
02.10.25

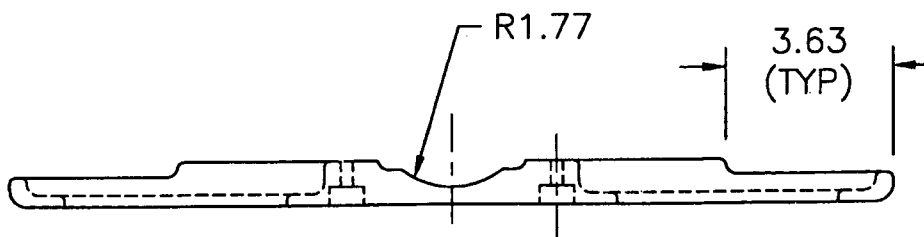
w/o 67022



SECTION A-A



SECTION B-B



SECTION C-C

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